






PRELIMINARY ISSUE

Work Order ID 67481

Tuesday, March 22, 2011 2:43:18 PM

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Item ID: D4323-1 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Cabin Wall, LH Aft
Start Date: 3/22/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 3/23/2011 Req'd Qty: 1.00  Customer:
Reference:





Approvals: Process Plan: 11 Date: 11-03-22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4323	<u>PA1</u> <u>ADA</u>

100		0.00							
									
HandThermo	Memo	0.00				<u>x 1</u>			<u>DL</u>
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								<u>11/03/23</u>

105		0.00							
									
HandThermo	Memo	0.00				<u>x 1</u>			<u>DL</u>
Hand Finishing Thermoforming	Dry Sheet as per QS1022 KYDEX								<u>11/03/23</u>

Temp: 150°F
Time IN: 4:00 pm 11/03/22
Time OUT: 2:00 am 11/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Thermoform	0.00							
Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA099 using tool DT9727 Dwg Rev: <u>PAS</u> Folio Rev: <u>A</u>	0.00				x1			DL 11/03/23
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00				x1			DL 11/03/23
Quality Control	Visually inspect part for proper formation and texture								
130 	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									Parts to be trained @ eagle. Donut watch Dwg. 8/03/23

W/O:		WORK ORDER CHANGES					
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Accept

Revision ID: PRELIM

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Required Date: 3/23/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Complete FAI document

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Packaging	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo <i>Reorder PO 4007</i>	0.00							<i>4/13/08</i> 
180  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							<i>11/5/16</i> 

*RD2370**WU0329*

POSITIVE RECALL

EFFECTIVE *11/3/13*RELEASED *MP*AUTH *W*
DATE *11/05/13*

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Tuesday, March 22, 2011 2:43:25 PM

Work Order ID: 67481



Parent Item: D4323-1



Parent Item Name: Cabin Wall, LH Aft

Start Date: 3/22/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.02 new issue DD verf:EC
Drawing Update 11/03/22

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MKYD6185S.080-P3-
62015

Purchased

No

100

sf

948.0376

15.9305

16.76895



6185 KYDEX .080"

Location

Loc Qty

Loc Code

therm

948.037564

109703

81.189115

116576

866.848449

Wh
11/03/23

16.76895 sq Ft.

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell [dcampbell@dartaero.com]
Sent: Wednesday, March 23, 2011 9:21 AM
To: 'Daryl Leger'
Cc: Harvey Siemens
Subject: D4323 Parts

Hi Daryl,

As per our conversation this morning, you can release the D4323-1/-2/-19/-20 parts for shipping to YYC without having trimmed them first. This means that the dimensions will not match the drawings, but since these are essentially "prototype" parts, they will be trimmed to fit here in YYC. The drawings will be modified as per the final fitting and trimming.

Cheers.

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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3/23/2011

Daryl Leger

From: Daryl Leger [dleger@dartaero.com]
Sent: Wednesday, March 23, 2011 10:15 AM
To: 'Daniel Campbell'
Cc: 'Harvey Siemens'; Linda Lacelle (llacelle@dartaero.com)
Subject: RE: D4323 Parts

Dan

I will do my best to ship the parts today.

Please note: If the parts are deemed acceptable, please notify the proper authority at Dart so that the positive recall can be removed on the Work Orders.

Daryl

From: Daniel Campbell [mailto:dcampbell@dartaero.com]
Sent: Wednesday, March 23, 2011 9:21 AM
To: 'Daryl Leger'
Cc: Harvey Siemens
Subject: D4323 Parts

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Cheers.

Daniel Campbell
Mechanical Engineer
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3/23/2011

